

Work Order ID 82263

82263

Page 1

March-27-12 2:45:00 PM

Item ID: D2281 Accept

Revision ID:

Item Name: Jack Saddle

Start Date: 27/03/2012 Start Qty: 100.00 ***100***

Required Date: 10/04/2012 Req'd Qty: 100.00 ***100***

Reference:

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: WCS Date: 12/03/12 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2281	Rev G								

100

100

Waterjet

FLOW CNC Waterjet

304 .080

FLOW WATER JET

Memo

1-Cut as per Dwg D2281 Dwg Rev: G Prog Rev: G 2-
Deburr if necessary

0.00

0.00

FB 12-5-10

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

FB 12-5-10

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

(100)

WJ 12-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Small Fab	0.00							
130	Small Fab	0.00							
Small Fab	Memo								
Small Fab	Deburr								

140	NC BRAKE	0.00							
140	Brake NC	0.00							
Brake NC	Memo								
Brake NC	Form as per D2281 using D2281-T2								

150	QC5- Inspect part completeness to step on W/O	0.00							
150	QC	0.00							
Quality Control	Memo								

N/A

S
12/05/11

100

100

12/05/14

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Setup Start ***NS1***

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Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

100 J u c 12-5-14

12/5/15

ME 12-05-15

W/O:		WORK ORDER CHANGES					
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Picklist Print

March-27-12 2:45:05 PM

Page 1

Work Order ID: 82263

82263

Parent Item: D2281

D2281

Parent Item Name: Jack Saddle

Start Date: 27/03/2012

Required Date: 10/04/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased		No		100	sf	100.6000	0.125	13.15789			
									**				B12-5-16
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						MAT020		100.6					
						117933		6.6					
						119276		94		119276			

M304S14GA

304SS sheet .080

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DART AEROSPACE LTD		Work Order:	82263
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.478	2		V RCL	
4.114	+/-0.010	4.112	2		V	
2.933	+/-0.010	2.937	2		V	
1.535	+/-0.010	1.543	2		V	
0.354	+/-0.010	.353	2		V	
0.354	+/-0.010	.354	2		V	
0.604	+/-0.010	.604	2		V	
2.000	+/-0.010	2.003	2		V	
3.396	+/-0.010	3.397	2		V	
3.646	+/-0.010	3.648	2		V	
4.000	+/-0.010	4.004	2		V	
1.525	+/-0.010	1.532	2		V	
2.475	+/-0.010	2.476	2		V	
Ø0.323	+0.006/-0.001	.323	2		V	
0.080	+/-0.010	.075	2		V	

Measured by:	RB
Date:	12-5-10

Audited by:	<i>[Signature]</i>
Date:	12-05-10

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	<i>[Signature]</i>

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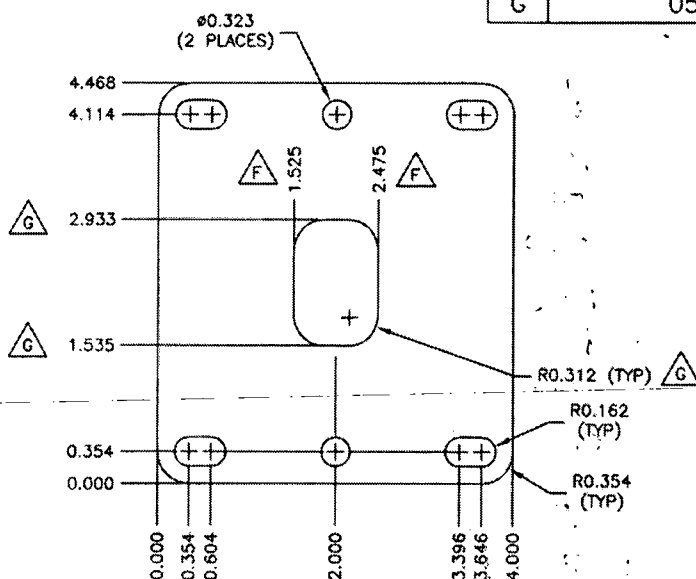
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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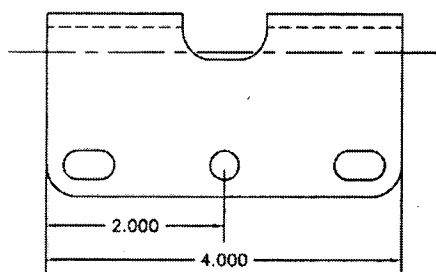


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE		SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

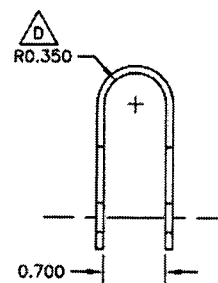
RELEASED
[Signature]
05/08/11



FLAT LAYOUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82263 MJS
12/03/07



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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